

Work Order ID 132276

Tuesday, May 05, 2015 2:53:42 PM

132276

Page 1

Item ID: 647.1710 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plate
 Start Date: 5/05/15 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/22/15 Req'd Qty: 8.00 ***8*** Customer:
 Reference: REWORK

Approvals: Process Plan: *MF* Date: 15.5.5 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.1700	C2

105 0.00

105 8 FF MAY 06 2015

Small Fab Memo 0.00

Small Fab PULL FROM STOCK

647.1710 X8

B: 91798 X6

B: 93277 X2

REDRILL HOLES TO NEW DIMENSION:

.257 AS PER ECN 15-555

115 0.00

115 8 FF 41 - for C.R.

HandFinish Memo 0.00

Hand Finishing TOUCH-UP HOLES 15-5-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 132276

Tuesday, May 05, 2015 2:53:42 PM

132276

Page 2

Item ID: 647.1710

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Plate

Stop

NS2

Start Date: 5/05/15

Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/22/15

Req'd Qty: 8.00

8

Customer:

Reference: REWORK

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

125

125

Packaging

Memo

0.00

Packaging

REPACKAGE USING NEW BATCH NUMBERS.

DA:
6
9-89

8 ~~125~~ MAY 07 2015

220

220

QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

ML5 MAY 11 2015

ML5 MAY 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER : ☐																									

Picklist Print

Tuesday, May 05, 2015 2:53:47 PM

Page 1

Work Order ID: 132276

132276

Parent Item: 647.1710

647 1710

Parent Item Name: Plate

Start Date: 5/05/15

Required Date: 5/22/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.1710		Manufactured	No				Each	0.0000		8			

647 1710

Plate

B 91798 X 6

Q3273 X 2

 15-5-6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

04702

SHEET 1 C 2

DWG NO. 647.1700

REV: C

PREPARED
BY:

J. BECKER

DATE: 03/18/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: SKID DEFLECTOR ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED HOLE DIMENSION. ADDED DELTA NOTES 7-10.

ECR #:

ACTIONS:

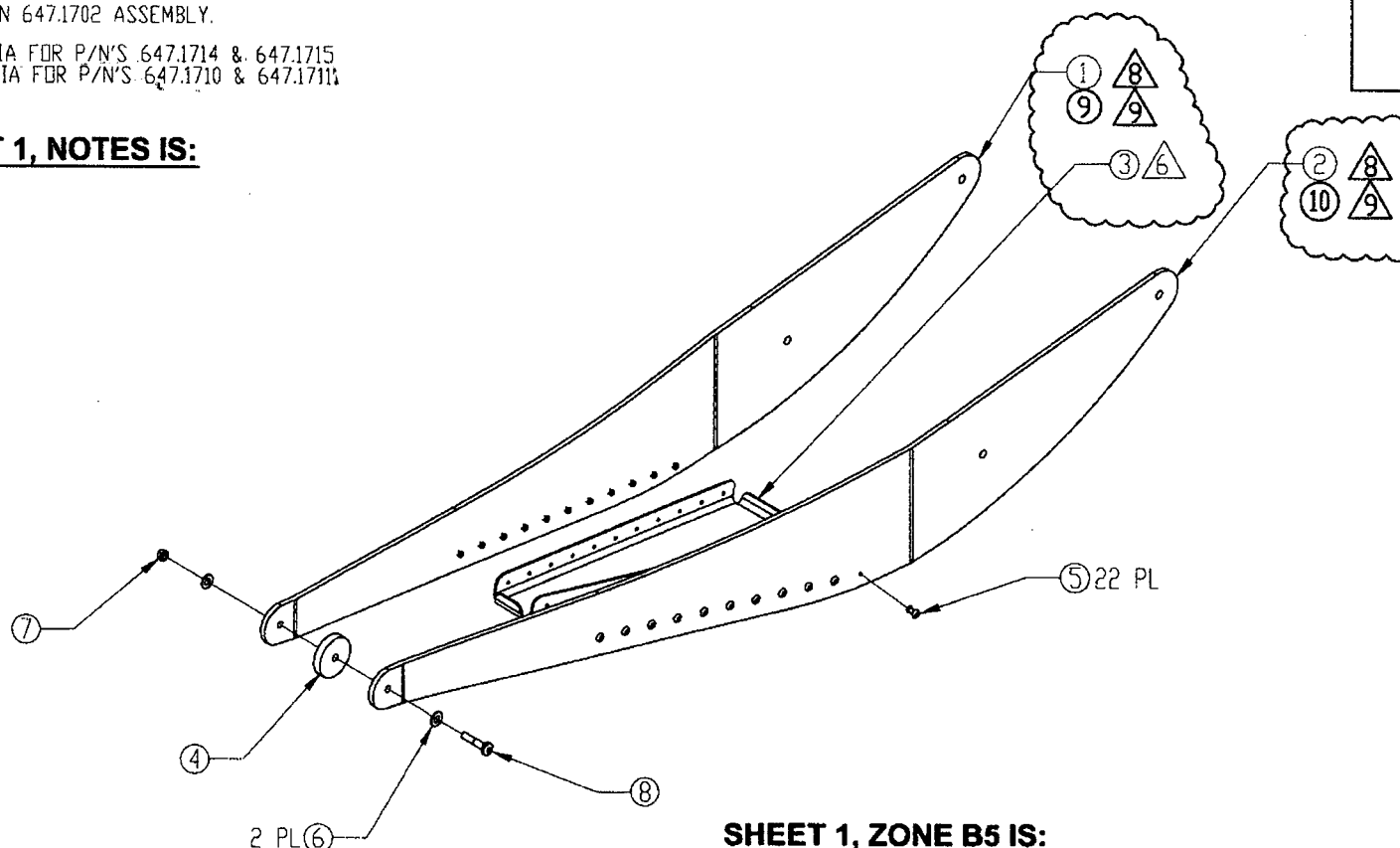
7 WITH EXCEPTION OF HOLE DIMENSION. ALL DIMENSIONS SAME AS
P/N 647.1710 AND P/N 647.1711. RESPECTIVELY.

8 FOR P/N 647.1701 ASSEMBLY.

9 FOR P/N 647.1702 ASSEMBLY.

10 .323" DIA FOR P/N'S 647.1714 & 647.1715
.257" DIA FOR P/N'S 647.1710 & 647.1711

SHEET 1, NOTES IS:



SHEET 1, ZONE B5 IS:

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRU

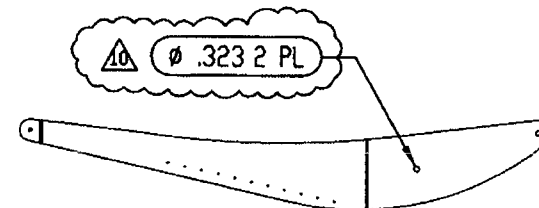
☐ ICA ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

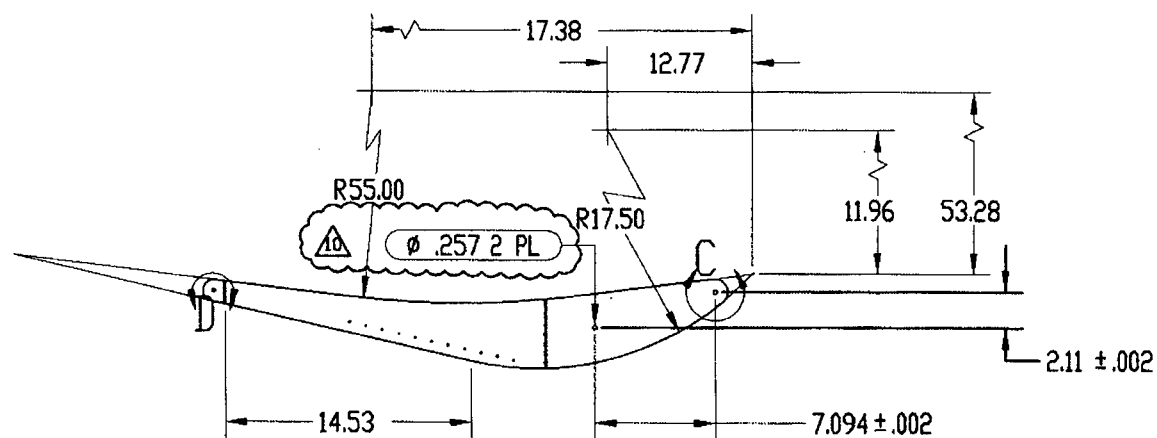
DER REVIEW REQUIRED

☐ YES ☒ NO



647.1714 SHOWN
647.1715 OPPOSITE 

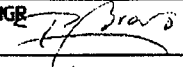
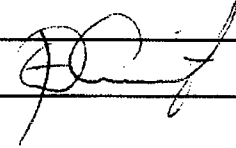
SHEET 3, ZONE C8 IS:



SHEET 3, ZONE D4 IS:

APICAL

INDUSTRIES, INC.

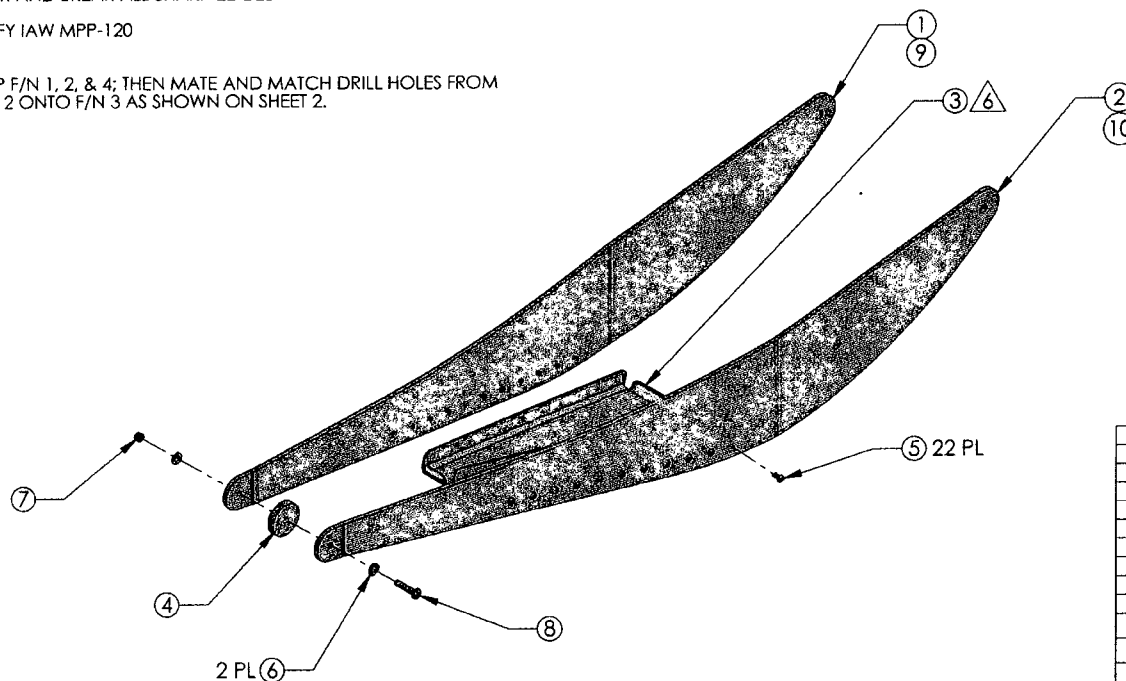
ENGINEERING CHANGE NOTICE NC 04679				SHEET 1 OF 1	
DWG NO. 647.1700		REV: C	PREPARED BY: J. BECKER	DATE: 09/10/14	EFFECT ON DWG ☐ INC. ☒ UNINC.
DWG TITLE: SKID DEFLECTOR ASSY					
APPROVED BY:	ENGR 	MFG 	QC 	EFF: CURRENT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED BOM QUANTITY FOR 647.1702.			

6	R	601.1607	2	2	WASHER	NAS1149F0332P	
5	R	601.1915	22	22	RIVET	CR3213-4-4	
F/N	TC	PART NUMBER	QTY		DESCRIPTION	MATERIAL	SPECIFICATION
			.1702	.1701			
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
☐ MDL ☐ INSTALL INSTRU ☐ ICA ☒ BOM						☐ MAJOR ☒ MINOR	☐ YES ☒ NO

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NOTES:

- 1 MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-250/12
- 2 MATERIAL: 6061-T6 ALUMINUM BAR IAW AMS-QQ-A-250/11
- 3 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK; PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER, COLOR BLUE; PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 4 DEBURR AND BREAK ALL SHARP EDGES
- 5 IDENTIFY IAW MPP-120
- 6 CLAMP F/N 1, 2, & 4; THEN MATE AND MATCH DRILL HOLES FROM F/N 1 & 2 ONTO F/N 3 AS SHOWN ON SHEET 2.



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	LAST PROTOTYPE REVISION: PR2		N/C
N/C	INITIAL RELEASE	08/05/09	P. BRAVO
A	INCORPORATED ECN'S 02937 & 03921	06/07/13	P. BRAVO
B	INCORPORATED ECN 03970	07/03/13	P. BRAVO
C	INCORPORATED ECN 04058	08/14/13	P. BRAVO

UNINCORPORATED ECN(s)

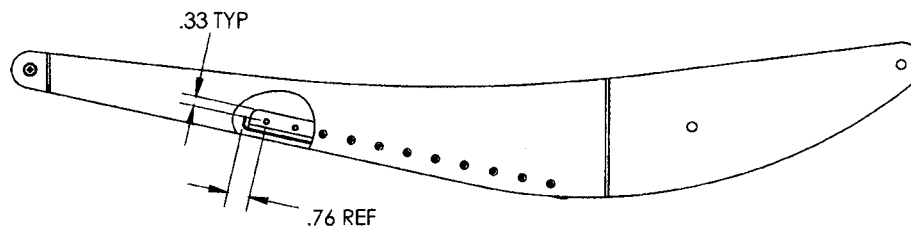
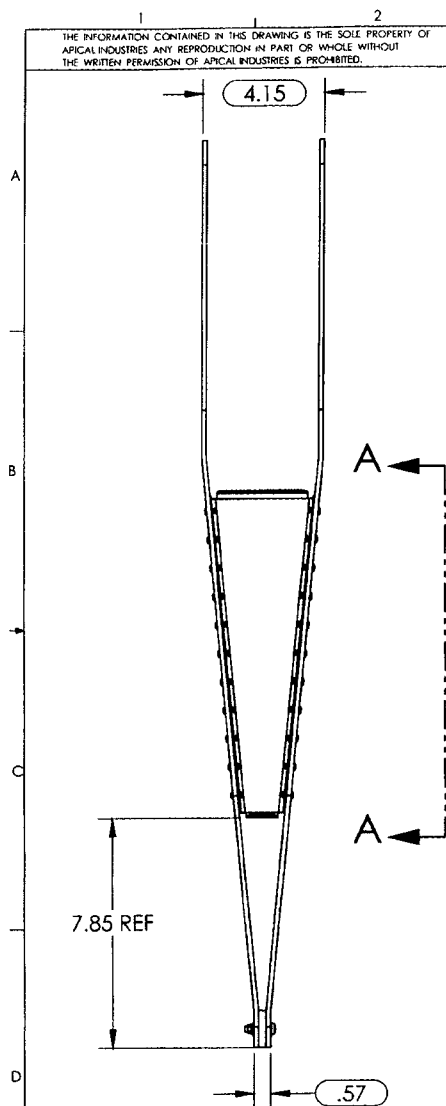
04079, 04702

QTY	FIN #	PART #	DESCRIPTION	MAT'L	SPEC.
1		10	647.1715 PLATE		
1		9	647.1714 PLATE		
1	1	8	601.1622 SCREW	MS27039-1-14	
1	1	7	601.2943 LOCKNUT	MS21042-3	
1	2	6	601.1607 WASHER	NAS1149F0332P	
1	22	5	601.1915 RIVET	CR3213-4-4	
1	1	4	647.1713 SPACER		
1	1	3	647.1712 GUSSET		
1	1	2	647.1711 PLATE		
1	1	1	647.1710 PLATE		
X			647.1702 SKID DEFLECTOR ASSY		
	X		647.1701 SKID DEFLECTOR ASSY		
1702	1701				

PARTS LIST	
ORIGINAL DATE (MM/DD/YY)	08/05/09
DRAWN BY J. CLARK	DESIGNED BY P. BRAVO
APPROVED BY P. BRAVO	CONTRACT NO.
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.003 ANGLES ±.5°	

APICAL INDUSTRIES			
2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300			
SKID DEFLECTOR ASSY			
SU B	CAGE CODE 07M426	DWG. NO. 647.1700	REV. C
SCALE NONE		SHEET 1 OF 5	

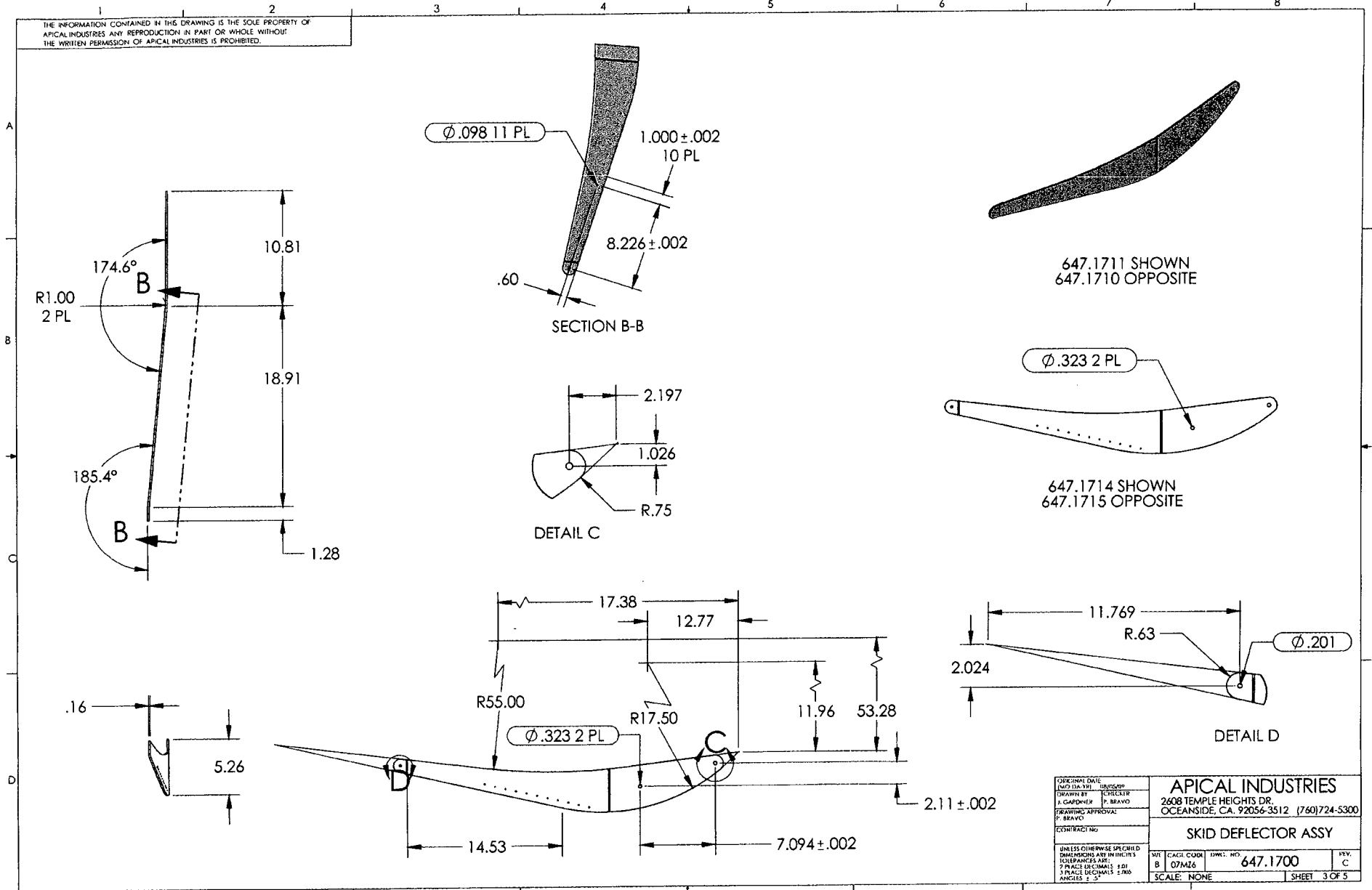
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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



SECTION A-A

ORIGINAL DATE MAY 04 1981		DESIGNER L. CAMERON		APICAL INDUSTRIES	
DRAWN BY L. CAMERON		CHECKED P. BRADY		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRADY		CONTRACT NO.		SKID DEFLECTOR ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SZ B	CAGE CODE 07M26	QWTS. NO. 647.1700	REV. C
SCALE NONE		SHEET 2 OF 5			

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647.1711 SHOWN
647.1710 OPPOSITE

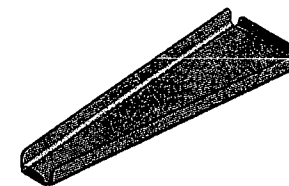
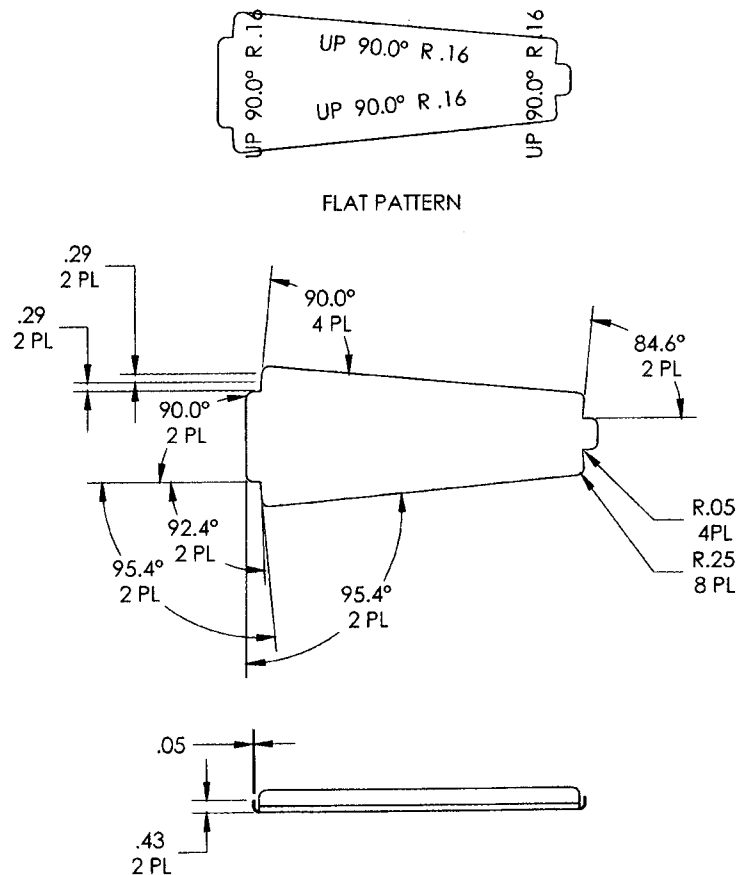
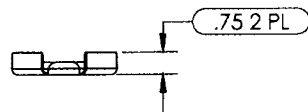
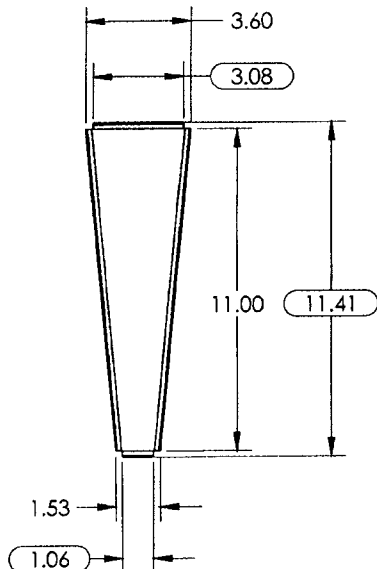
Ø.323 2 PL

647.1714 SHOWN
647.1715 OPPOSITE

DETAIL D

ORIGINAL DATE (MM/DD/YYYY)		DESIGNED BY A. GARDNER		CHECKED BY P. BRAVO	
DRAWING APPROVAL P. BRAVO		CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ± .01 ANGLES ± .5°		SCALE: NONE		SHEET 3 OF 5	
REV. C		PART NO. 647.1700		REV. C	

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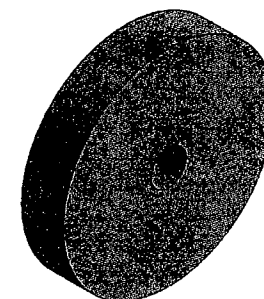
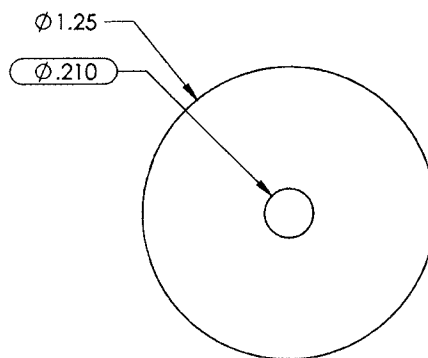
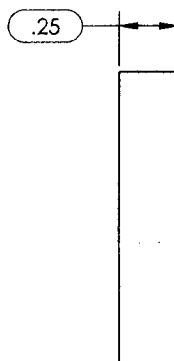
647.1712

ORIGINAL DATE: 07/05/09
DRAWN BY: J. CARDEN
CHECKED BY: P. BRADY
DRAWING APPROVAL: P. BRADY
CONTRACTING:
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300
SKID DEFLECTOR ASSY
SHEET 4 OF 5

SCALE: NONE
DWG. NO: 647.1700
REV. C

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



647.1713

ORIGINAL DATE		APICAL INDUSTRIES	
DESIGNED BY	CHUCKER	2608 TEMPLE HEIGHTS DR.	
DRAWN BY	P. BRAVO	OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL		SKID DEFLECTOR ASSY	
P. BRAVO		SHEET 5 OF 5	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED		DWG. NO. 647.1700	
DIMENSIONS ARE IN INCHES		REV. C	
TOLERANCES ARE:		SHEET 5 OF 5	
2 PLACE DECIMALS ±.01			
3 PLACE DECIMALS ±.005			
ANGLES ±.5°			

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 15.04.13	Job No.:	ADR Yes/No: N	ADR Date:	ECN #: 15- 555
Product No.: Apical 145-21, 350-61		Created By: KJ	Approved By: <i>[Signature]</i>	
Product Name: Cable Cutters		Checked By: <i>[Signature]</i>		

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)	Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	NF		DQA / QA Coord.	Y	PS/ED	
Production Manager / Coord.	Y	LL/MF		QC Coordinator	Y	PD	
Purchasing Coord.	N	CL		Customer Support	Y	SW/LM	
Production Engineering Coord.	Y	DD/JLM		Customer Technical Support	Y	MB/HS	15.04.13
Production Engineering Coord.	N	DL		Marketing	N	KO/SL	
Customer Order Processing	N	SL/BG		Sales Support Manager	N	CP	

Reason for Change:
Revised hole dimensions, added delta notes 7-10 (647.1700), Revised dimensions of holes (650.9200)

Documents Affected:
Release 647.1700 Rev C2.(145-21) .
Release 650.9200 Rev NC1 (350-61)

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: _____

PAPERWORK UPDATE ☐

PARTS MUST COMPLY ☒

PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3	Notify Augusta Westland	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Update Product Compatability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	N			
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approved/Preliminary Dwg PDF Files	Y	KJ	see below	15.04.13 <i>[Signature]</i>
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	N			
17	Update / Verify Airworthiness Release Certificate Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	N			
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:
Please update BOM per released drawing

W/O DONE to fix HOLE ON 647.1710 and 647.1711

ECN Verified & Complete: _____ Date: _____